

Work Order ID 126874

November-27-14 1:17:45 PM

126874

Page 1

Item ID: D350-591-122

Revision ID:

Item Name: Heli-Access-Step™ RH

Start Date: 11/27/14 Start Qty: 6.00

Required Date: 12/05/14 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2351-042	E								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC		0.00							
Doc.Control -USB or Paperwork	Memo Photocopy bluefile and type labels as per PPP D350-591-122 CHG005								
110	Large Fab	0.00							
110									
Large Fab		0.00							
Large Fab	Memo 1-Cut D2244-116 extrusion to 55.32" long as per Dwg D2351 using cutting table setup DT8185-G 2-Drill extrusion per Dwg D2351 using Jig DT8230 for rivets.								
130	BENDING MACHINE - SKIDTUBES	0.00							
130		0.00							
CNC Bend 1	Memo								
CNC Delta 100 Bender	Bend as per dwg D2351-042 using cnc bender and Folio FT 012. Use bend prog. D2351-042.								

6x

DAS
45
0.29

JAN 23 2015

6

6/14/12.1

14-12-1

Work Order ID 126874

November-27-14 1:17:45 PM

126874

Page 2

Item ID: D350-591-122

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Step™ RH

Stop ***NS2***Start Date: 11/27/14 Start Qty: 6.00 ***6***

Cust Item ID:

Required Date: 12/05/14 Req'd Qty: 6.00 ***6***

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

150

Large Fab

0.00

150

Large Fab

Memo

0.00

Large Fab

1-Bevel Fwd and Aft end for welding
2-Weld Aft End Bracket per QSI 004 & Dwg D2351 using Welding Jig DT8033
A/RAluminum Rod **128385**
3-Do not Grind Flush

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00

160

QC

Memo

0.00

Quality Control

DAS
43
9-89

DEC 09 2014

Work Order ID 126874

November-27-14 1:17:45 PM

126874

Page 3

Item ID: D350-591-122

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Step™ RH

Stop ***NS2***

Start Date: 11/27/14 Start Qty: 6.00

6

Cust Item ID:

Required Date: 12/05/14 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

DAS
38
9-89

DEC 09 2014

180

Chemical Conversion Coat per QSI005 4.1

0.00

180

HandFinish

Memo

0.00

Hand Finishing

CPC/11.12.10 C

190

QC7-Inspect Chemical Conversion Coat

0.00

190

QC

Memo

0.00

Quality Control

DAS
38
9-89

DEC 15 2014

Work Order ID 126874

November-27-14 1:17:45 PM

126874

Page 4

Item ID: D350-591-122 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access-Step™ RH
 Start Date: 11/27/14 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 12/05/14 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 *220* Large Fab Large Fab	Large Fab Memo 1-Rivet Leg Assembly as per Dwg D2351 2-Weld Fwd End Plate per QSI 004 & Dwg D2351 A/RAluminum Rod <u>12756</u> 3-Grind end plate flush.	0.00 0.00	<i>PC 14.12.22</i>			<u>6</u>			
225 *225* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>6</u>	<u>14.12.23</u>		DAS 9 9-89
230 *230* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				<u>6</u>	<u>14.12.23</u>		DAS 9 9-89

Work Order ID 126874

November-27-14 1:17:45 PM

126874

Page 5

Item ID: D350-591-122 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access-Step™ RH
 Start Date: 11/27/14 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 12/05/14 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

250	Chemical Conversion Coat per QSI005 4.1	0.00							
-----	---	------	--	--	--	--	--	--	--

250									
HandFinish	Memo	0.00							
Hand Finishing									

260	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
-----	--	------	--	--	--	--	--	--	--

260									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 7:15. OVEN TEMPERATURE: 320° FINISH TIME: 8:15.								

270	Wing Walk as per dwg QSI005 4.4 Batch 130930	0.00							
-----	--	------	--	--	--	--	--	--	--

270									
HandFinish	Memo	0.00							
Hand Finishing									

DAS 34 9.89

x CORH / 1510108

Work Order ID 126874

November-27-14 1:17:45 PM

126874

Page 6

Item ID: D350-591-122

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Step™ RH

Stop ***NS2***

Start Date: 11/27/14 Start Qty: 6.00

6

Cust Item ID:

Required Date: 12/05/14 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC3- Inspect Part Finish

0.00

280

QC

Memo

0.00

Quality Control

38
9-89

JAN 07 2015

290

Pick Kit

0.00

290

Packaging

Memo

0.00

Packaging

DAS
28
9-89

JAN 20 2015

300

QC4- 100% Inspect kits for completeness

0.00

300

QC

Memo

0.00

Quality Control

DAS
46
9-89

JAN 23 2015

Work Order ID 126874

November-27-14 1:17:45 PM

126874

Page 7

Item ID: D350-591-122 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Access-Step™ RH
Start Date: 11/27/14 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 12/05/14 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
310	Packaging	0.00				6	DAS 416		JAN 23 2015
310									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-591-122 Location: <u>037</u> PPP Rev: _____								
320	QC21- Final Inspection - Work Order Release	0.00							
320									
QC	Memo	0.00							
Quality Control									

15/1/28 JF
WMC
15-1-27

Picklist Print

November-27-14 1:17:39 PM

Page 1

Work Order ID: 126874

126874

Parent Item: D350-591-122

D350-591-122

Parent Item Name: Heli-Access-Step™ RH

Start Date: 11/27/14

Required Date: 12/05/14

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:E02.10.21Re-format; Incorporated D2351-041 IPPKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3-37A		Purchased	No			290	Each	140.0000	2	12			
AN3-37A									**			DAS 28 9-89	JAN 20 2015
Bolt													

DAS
46
9-89

Location	Loc Qty	Loc Code
FG	10	
119086	10	
ST347	130	
m130325	30	
m130466	100	

AN4-13A		Purchased	No			290	Each	420.0000	3	18			
AN4-13A									**			DAS 28 9-89	
Bolt													

DAS
46
9-89

Location	Loc Qty	Loc Code
CA	2	
m129682	2	
FG	20	
122808	20	
GA	58	
m125709	14	
m130325	44	
ST325A	278	
m130716	278	
ST344	62	
121652	4	
m127432	36	
m127817	22	

Picklist Print

November-27-14 1:17:40 PM

Page 2

Work Order ID: 126874

Parent Item: D350-591-122

Parent Item Name: Heli-Access-Step™ RH

126874

D350-591-122

Start Date: 11/27/14

Required Date: 12/05/14

Start Qty: 6.00

Required Qty: 6.00

D2230-1

Manufactured No

290

Each

445.0000

1 6

DAS

28

9-89

JAN 20 2015

D2230-1

Mounting Lug

DAS
46
9-89

Location

Loc Qty

Loc Code

FG

4

84136

4

ST521

164

101834

1

110834

4

115306

79

116380

80

ST546A

277

113437

112

116381

148

116382

17

D2230-3

Manufactured No

290

Each

268.0000

1 6

DAS

28

9-89

D2230-3

Mounting Lug

DAS
46
9-89

Location

Loc Qty

Loc Code

FG

7

109344

4

89045

3

ST521

101

108668

1

109344

2

114151

1

114921

4

116378

93

ST525A

160

123324

160

November-27-14 1:17:40 PM

Shop Packet Print

Page 2

Picklist Print

November-27-14 1:17:40 PM

Page 3

Work Order ID: 126874

126874

Parent Item: D350-591-122

D350-591-122

Parent Item Name: Heli-Access-Step™ RH

Start Date: 11/27/14

Required Date: 12/05/14

Start Qty: 6.00

Required Qty: 6.00

D2244-116

Manufactured No

110

Each

188.0000

0.5

3

D2244-116

STEP EXTRUSION

**

Cpl 14.12.3

Location	Loc Qty	Loc Code
HALL	138	
117818	138	
WA003	49.9999632	
104940	41	3
60307	9	

D2582

Manufactured No

Each

18.0000

6

D2582

Hi-Skid Step Leg Ass'Y

**

Cpl 14.12.15

Location	Loc Qty	Loc Code
WA003	18	
106091	1	
111490	1	
121022	16	6
	220	

D2673-34

Manufactured No

Each

17.0000

1

6

D2673-34

End Plate

**

Cpl 14.12.3

Location	Loc Qty	Loc Code
WA003	17	
113204	13	6
117775	4	

D2850-2

Manufactured No

150

Each

11.0000

1

6

D2850-2

End Cap

**

Cpl 14.12.3

Location	Loc Qty	Loc Code
WA003	11	
111517	1	1
119501	10	5

November-27-14 1:17:43 PM

Shop Packet Print

Page 3

Picklist Print

November-27-14 1:17:43 PM

Page 4

Work Order ID: 126874

126874

Parent Item: D350-591-122

D350-591-122

Parent Item Name: Heli-Access-Step™ RH

Start Date: 11/27/14

Required Date: 12/05/14

Start Qty: 6.00

Required Qty: 6.00

D2856-400

Manufactured No

290 f

115.6000

0.6 4

**

DAS
28
9-89

JAN 20 2015

D2856-400

Abrasion Strip 4" Wide (Per Foot)

DAS
46
9-89

Location

Loc Qty

Loc Code

PKG016

115.6

117887

115.6

cut (1) at 7.20"

MS20600-AD4W3

Purchased No

Each

1,189.000

96

**

14-12-15

MS20600-AD4W3

Cherry Rivets

Location

Loc Qty

Loc Code

CCK004

600

m129795

600

ST309

522

m130018

522

WA003

67

m127476

7

m129278

60

MS21042L3

Purchased No

290

Each

1,433.000

2 12

**

DAS
28
9-89

MS21042L3

Nut

DAS
46
9-89

Location

Loc Qty

Loc Code

FP001

500

M130922

500

ST305

933

123900

73

M127410

11

M127831

41

M128401

34

M128754

77

M130799

697

131264

November-27-14 1:17:44 PM

Shop Packet Print

Page 4

Picklist Print

November-27-14 1:17:44 PM

Page 5

Work Order ID: 126874

Parent Item: D350-591-122

Parent Item Name: Heli-Access-Step™ RH

126874

D350-591-122

Start Date: 11/27/14

Required Date: 12/05/14

Start Qty: 6.00

Required Qty: 6.00

MS21042L4

Purchased

No

290

Each

4,238.000

3 18

DAS

28

9-89

JAN 20 2015

MS21042L4

Locknut

DAS
46
9-89

Location

Loc Qty

Loc Code

ST007	12	
121444	12	
ST260a	2000	
m130799	2000	18
ST273A	744	
m129934	744	
ST305	1482	
111827	2	
126275	5	
m126015	12	
m126275	32	
m127255	63	
m127376	9	
m127813	741	
m128300	69	
m129472	49	
m130922	500	

November-27-14 1:17:44 PM

Shop Packet Print

Page 5

Picklist Print

November-27-14 1:17:44 PM

Page 6

Work Order ID: 126874

Parent Item: D350-591-122

Parent Item Name: Heli-Access-Step™ RH

126874

D350-591-122

Start Date: 11/27/14

Required Date: 12/05/14

Start Qty: 6.00

Required Qty: 6.00

NAS1149D0363J

Purchased

No

290

Each

2,067.000

(4) 24

NAS1149D0363.J

Washer

DAS
46
9-89

Location

Loc Qty

Loc Code

GA

7

124392

7

ST260a

600

m130799

600

ST269

483

m123441

5

m126319

441

m130358

37

ST510a

977

m128429

977

**

DAS
28
9-89

JAN 20 2015

722378

NAS1149D0463J

Purchased

No

290

Each

6,997.000

6 36

NAS1149D0463.J

WASHER

DAS
46
9-89

Location

Loc Qty

Loc Code

CA

459

M129682

459

ST260a

6419

M129390

1593

M130799

4826

ST269

119

16941

8

M126221

20

M127813

6

M127904

16

M128591

44

M128995

25

**

DAS
28
9-89

36

November-27-14 1:17:44 PM

Shop Packet Print

Page 6

Picklist Print

November-27-14 1:17:44 PM

Page 7

Work Order ID: 126874

Parent Item: D350-591-122

Parent Item Name: Heli-Access-Step™ RH

126874

D350-591-122

Start Date: 11/27/14

Required Date: 12/05/14

Start Qty: 6.00

Required Qty: 6.00

D2732-030 Manufactured No

290 Each

171.0000 2 12

D2732-030

Rubber Cushion - 30" (Replaces P/N G13013-4)

**

DAS
28
9-89

JAN 2 0 2015

*cut(2) at 2" per kit
= x6*

DAS
46
9-89

Location

Loc Qty

Loc Code

FG

104

107346

66

117118

2

124849

36

PKG016

67

123578

31

124849

36

cut (2) at 3.00"

AN4-16A

Purchased No

290 Each

64.0000 2 12

AN4-16A

Bolt

**

DAS
28
9-89

DAS
43
9-89

Location

Loc Qty

Loc Code

FG

5

121541

5

ST343

59

M128324

19

M128978

4

M129590

2

M130466

34

131139

November-27-14 1:17:44 PM

Shop Packet Print

Page 7

DART

DESIGN KE	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2351	REV. E SHEET 1 OF 2
DATE 05.11.14		TITLE HIGH FLOAT STEP ASSEMBLY	SCALE NTS
A	95.02.15	NEW ISSUE	
B	97.05.22	END CAPS CHANGED	
C	97.07.23	ADDED BUSHING AND FACING INFO	
D	98.12.17	CHANGED TO BEND, D2850 REPLACES D2357 & D2358, INCORP. DEO 9084	
E	05.11.14	UPDATE FINISHING NOTE	

D2351 HIGH FLOAT STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY -041	QTY -042
D2351-041	High Float Step Assembly (LH)	X	
D2351-042	High Float Step Assembly (RH)		X
D2244-55.4	STEP EXTRUSION*	1	1
D2582	STEP LEG ASSEMBLY	1	1
D2673-34	STEP END PLATE	1	1
D2850-1	END BRACKET	1	
D2850-2	END BRACKET		1
MS20600AD4W3	RIVETS	16	16

*cut per drawing

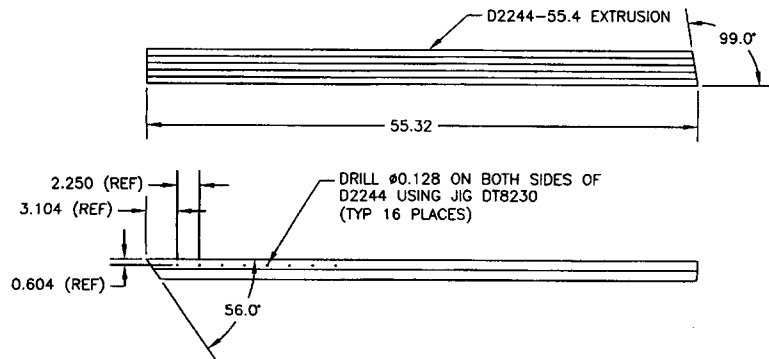
ht 292 07m

RELEASED
05.11.28PH
ECN 1105**UNDER REVIEW**07.11.29
PERMITS 263

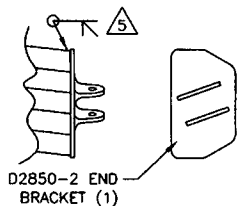
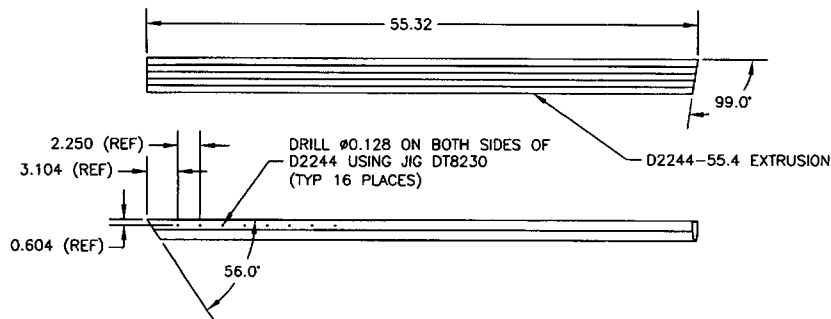
Copyright © 1995 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

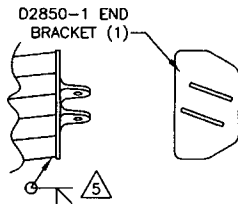
D2351-2 CUTTING/DRILLING DETAIL
RIGHT STEP



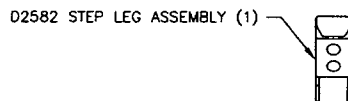
D2351-1 CUTTING/DRILLING DETAIL
LEFT STEP



DETAIL A
SCALE: 1:4



DETAIL B
SCALE: 1:4

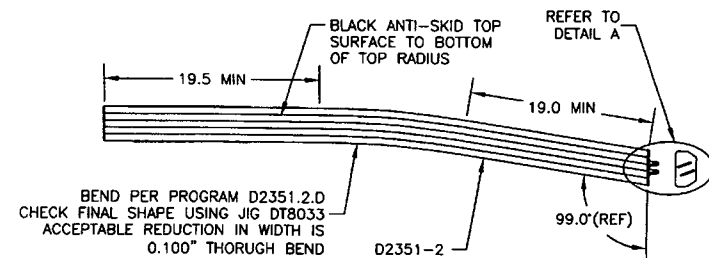


GENERAL NOTES

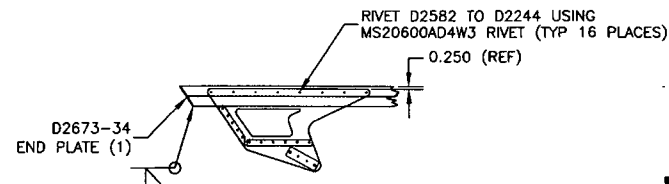
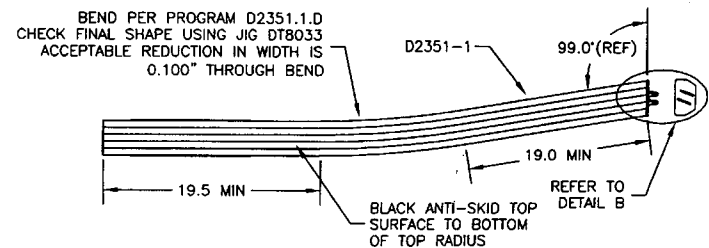
- 1) WELD PER DART QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

CHAMFER D2244 EXTRUSION 0.075"x45" BEFORE WELDING D2850-1 OR D2850-2 IN PLACE. DO NOT GRIND FLUSH.

D2351-042 BENDING/ASSEMBLY DETAIL
RIGHT STEP



D2351-041 BENDING/ASSEMBLY DETAIL
LEFT STEP



RELEASED
05.11.28

UNDER REVIEW

COPYRIGHT © 1995 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DESIGN KE	DRAWN BY PH	DART	DART AEROSPACE LTD. HAMPSHIRE, ENGLAND
CHECKED #	APPROVED #	DRAWING NO. D2351	REV. E
DATE 05.11.14	TITLE HIGH FLOAT STEP ASSEMBLY	SHEET 2 OF 2	SCALE 1:12

REFERENCE ONLY

JAN 23 2015

DART AEROSPACE LTD.

DAS
46
Q-89

ICA-D350-591
ICA Page 28 of 29

32.6 PARTS LIST

Qty -111A	Qty -113	Qty -115	Qty -117A	Qty -119	Qty -133	Part Number	Description
X						D350-591-111A	<i>Heli-Access-Step</i> ™, Long Step – High Skid
	X					D350-591-113	<i>Heli-Access-Step</i> ™, Short Step – High Skid
		X				D350-591-115	<i>Heli-Access-Step</i> ™, Short Step – Low Skid
			X			D350-591-117A	<i>Heli-Access-Step</i> ™, Pre-Flight Step
				X		D350-591-119	<i>Heli-Access-Step</i> ™, Long Step – Low Skid
					X	D350-591-133	<i>Heli-Access-Step</i> ™, Aft Maintenance Step
	1					D2310	STEP ASSEMBLY (HIGH-SHORT)
1						D2311	STEP ASSEMBLY (HIGH-LONG)
		1				D2354	STEP ASSEMBLY (LOW-SHORT)
				1		D2355	STEP ASSEMBLY (LOW-LONG)
					1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
4	2	2	2	2		D2171	CLAMP
4	2	2	2	2		D2182B035	CUSHION
					4	D2230-1	MOUNTING LUG
					4	D2230-3	MOUNTING LUG
8	4	4	4	4		D2274	RADIUS BLOCK
			1			D2362-041	SUPPORT BRACKET
2	1			1		D2362-3	SUPPORT BRACKET
		1				D2362-5	SUPPORT BRACKET
2	1	1	1	1	2	D2856-400-720	ABRASION STRIP
					1	D2945	MOUNTING PLATE
2	2	2		2		AN3-37A	BOLT
					2	AN4-7A	BOLT
					4	AN4-11A	BOLT
					8	AN4-14A	BOLT
		4				AN4-16A	BOLT
8	4			4		AN4-20A	BOLT
1	1	1	4	1		AN4-22A	BOLT
4	4	4		4		AN960JD10	WASHER
10	6	2	4	6	14	AN960JD416	WASHER
		4				AN960JD416L	WASHER
2	2	2		2		MS21042L3	NUT
9	5	5	4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-122	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-123	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-124	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
1	1	1	1	D2856-400-720	ABRASION STRIP
2	2	2	2	AN3-37A	BOLT
3	3	3	3	AN4-13A	BOLT
4	4	4	4	AN960JD10	WASHER
6	6	6	6	AN960JD416	WASHER
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT

• COPYRIGHT © 2002 BY DART AEROSPACE LTD. •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: 3

32-00-00

Work Order ID 126874

November-27-14 1:17:45 PM

126874

Page 1

Item ID: D350-591-122

Revision ID:

Item Name: Heli-Access-Step™ RH

Start Date: 11/27/14 Start Qty: 6.00

Required Date: 12/05/14 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC

Date:

SPC (Y/N):

Date:

Stop

NR2

Set Up ID:

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

100 Job Nbr

Revision Nbr

100

100

Document Control

0.00

DOCUMENT CONTROL

DC

Memo

0.00

Doc Control - USB or Paperwork

Photocopy bluefile and type labels as per PPP D350-591-122 CHG005

ML5

15-01-20

6

110

110

110

Large Fab

0.00

Memo

0.00

1-Cut D2244-110 extrusion to 55.32" long as per Dwg D2351 using cutting table setup DT8185-G
2-Drill extrusion per Dwg D2351 using jig DT18230 for rivets.

130

130

CNC Bender

BENDING MACHINE - SKIDTUBES

0.00

Memo

0.00

CNC Delta 100 Bender

Bend as per dwg D2351-042 using cnc bender and Folio FF 012. Use bend prog. D2351-042.

14-12-1

14-12-1